

AVIATION

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JUNE 8, 1925

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The Arctic Expedition: Left to Right, Rober, Nold, Byrd, Schur and Loening

VOLUME
XVIII

SPECIAL FEATURES

NUMBER
23

N.A.A. RESOLUTIONS

THE ADMINISTRATION'S AIR POLICY

THE DESIGN OF AIR COOLED CYLINDERS

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JUNE 8, 1925

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The Design of Air-Cooled Cylinders

By C. FAYETTE TAYLOR

ACKNOWLEDGMENT The ideas set forth in this article are based largely on the results of experiments made in the Engineering Division, Army Service, and coordinated in the laboratories of the Wright Aeronautical Corporation.

The fundamental requirements for air-cooled cylinders for military aircraft engines may be stated as follows:

(a) **Adaptability to Engine.** Unlike the water-cooled engine, which may have a large displacement, the air-cooled engine must be arranged primarily to secure proper cooling conditions for the cylinders. In other words, the engine must be to a large extent designed for the cylinders, rather than the cylinders for the engine. However, the design of an air-cooled cylinder is influenced considerably by the type of engine on which it is to be mounted and the position of the various matters to the stream of cooling air. These considerations affect the use of the cylinders and the arrangement of the cooling fan, the position of the intake and exhaust ports, and the location of the valve gear supports and spark plug bosses.

(b) **Maximum power output consistent with a reasonable fuel consumption.** This is obtained through correct combustion chamber design, suitable arrangement of port and valves, and proper piston and ring cooling.

(c) **Endurance.** The Army and Navy now require a minimum period between overhauls of approximately 200 hr. of running, and engine freedom from major failures. These results are obtained by proper selection and arrangement of material, by proper lubrication of the bearing surfaces, and by efficient cooling of all parts to avoid burning of the material, destruction of the lubrication, or fatigue failure brought on by an accelerated action of the parts.

(d) **Light weight is a fundamental consideration in all aircraft equipment, but it cannot be obtained at any considerable sacrifice of the first three items. Light weight is secured by careful selection and distribution of materials, also by being in mind the considerations noted under (a), (b) and (c).**

(e) **Cost of Production.** While this is a very important consideration, it must be placed at the bottom of the list for military equipment, since it is not desirable to make any excessive concessions to the other requirements simply to reduce production costs. For commercial engines, however, this would be one of the most important considerations, and one of the others might have to be compromised in its favor.

It is the purpose of this article to show how the fundamental requirements stated above are applied in detail to the design of an air-cooled cylinder for military engines.

Before starting the design of the cylinder, it is necessary to know the type and arrangement of the engine on which it is to be used, the normal speed of crankshaft rotation, and the power output required. It is also necessary to know the kind of fuel which is to be used, as this determines the maximum compression ratio which may be used. The term "compression ratio" is defined as the ratio of the combustion chamber volume with the piston at top dead center to the total cylinder volume with the piston at bottom dead center. For air-cooled cylinders operating on aviation gasoline, the practical high limit on compression ratio seems to be from 5.5 to 5.8, depending on the size of the cylinder. Having determined the compression ratio, we know from experience approximately what power may be obtained per cubic inch of displacement for a cylinder of average design at a given speed of rotation of the crankshaft. Table 1 shows the far greater type air-cooled cylinders running at various speeds, with a compression ratio of 5.5.

If our engine is to run, for instance, at 2,000 r.p.m. and is to give 48 hp. per cylinder, we can find the necessary displacement by selecting from table 1 the figure in the column opposite 2,000 r.p.m. and multiplying it by 48. This

gives 335.7 cu. in. as the displacement necessary for the cylinder taken as an illustration.

Having determined the displacement for the cylinder, it is necessary to select a bore and stroke which will give the displacement. Whether to select a large bore and a short stroke or a small bore and a long stroke, depends on the type of engine for which the cylinder is to be used. It is sometimes permissible to use a long-stroke cylinder in a V-type or vertical engine, but on a radial engine the stroke is disadvantageous on account of the resulting increase in the diameter of the engine. This very important consideration is that in a radial engine for larger valves in proportion to the displacement on the large bore, short-stroke cylinder. Modern American aircraft engine practice has tended toward cylinders in which the stroke is only slightly greater than the bore, as shown on those engines the ratio of bore to stroke ranges from 0.7 to 1.0, the latter being the so-called "square cylinder," in which the bore is equal to the stroke.

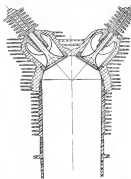


Fig. 1

Since the cylinder with relatively large bore valves gives the use of large valves, we may assume a bore-stroke ratio of 0.85. In order to get the desired 335.7 cu. in. and to meet this ratio, we have a cylinder at 5.375 in. bore by 5.67 in. stroke.

The compression ratio, here, and stroke of the engine have been determined, we are now ready to lay out the cylinder on the drafting board and proceed with the detail design.

The data given in table 1 shows the power output which may be expected from the average design. It is quite possible, however, to exceed these values appreciably by suitable

design of the principles noted herein, and this will give a very desirable margin in excess of the power actually required from the engine.

It is only under desirable to secure high power at the expense of fuel economy. Fortunately, however, conditions usually lead to a high power output tend to result along a most logical economy, so that these two factors can well be considered together.

The power output for a given size and speed is restricted largely by combustion chamber design, size of valves, size and shape of ports, and cooling of the cylinder. It has been the experience of nearly all experimenters that the nature of an approach to a spherical combustion chamber, the latter will be the results obtained. This chamber from the irregular combustion chamber surrounded by the head or T head engine, and confined so strictly to the radial valve engine which is now universal in aircraft engines. If the combustion chamber is to be approximately spherical in shape, the cylinder head must be approximately hemispherical and the valves and ports must be located to do so. As illustrated on Fig. 1, incidentally, this type of combustion chamber facilitates the cooling of the cylinder, since it is well exposed to the air blast and has a large surface for the application of cooling fins. Fig. 2 shows no surface design having a flat combustion chamber head. It has been found that this type of cylinder always has better, given a much higher fuel consumption, and generally gives a lower power output than the type shown in Fig. 1.

Valves

Having determined the shape of the combustion chamber, a feature necessary to decide upon the size of the intake and exhaust valves. Experience has shown that in order to develop maximum power, it is necessary to have one square inch of intake valve opening for each 30 cu. in. of piston displacement. It is desirable to have an equivalent amount of exhaust valve opening, but where the space for the valves is restricted, the exhaust valve size may be reduced by 10 per cent, where one square inch of valve opening serves as high as 40 cu. in. of piston displacement. Experiments have shown that it is possible to fit the valves in a head given a ratio of 1.25 of these diameter and still work on the full area of the valve opening, provided there is sufficient space between the edge of the valve and side of the combustion chamber, so that the gas flow will not be restricted at this point. The form given for valves also apply to the piston and connecting rod.

For air-cooled engine design, where the engines are run at speeds not exceeding 2,500 r.p.m. For the very high-speed engine, one square inch of valve opening for every 30 cu. in. of piston displacement is desirable.

Number

For the cylinder taken as an example, we may assume that the desired operating speed will not exceed 2,000 r.p.m., and that one square inch of valve opening area will be provided for every 30 cu. in. of piston displacement for both intake and exhaust. For cylinders of less than 200 cu. in. displacement, one detail engine appears to be unnecessary, and therefore the engine in question, only one inlet and one exhaust valve should be used. Assuming that the valve lift will be one-fourth of the valve diameter, we arrive at a valve diameter of 2.125 in. in the case with a lift of 0.53125 in. The shape of ordinary poppet valves, used from their size, has a small effect on engine performance, further details of valve design will be considered under the heading of "Scratchily."

One of the most important considerations is securing maximum power output in the size and shape of the intake and exhaust valves. The relative size of the ports must be such as to allow the maximum passage to the flow of the gases in and out of the cylinders, while their external shape is such as to cause a minimum resistance to the flow of the gases in and out of the cooling air around the cylinder head. In

order to effect the least possible restriction in gas flow, the passages within the ports must have many bends with plenty of area at the bends, especially around the valve guide bosses. Rapid changes of section must be avoided, and the area of any section of the passage must always be as great as, or greater than, the clear area of the valve opening. The external shape of the port will be considered under the next heading.

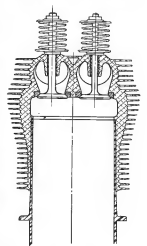


Fig. 2

Perhaps the most difficult problem in air-cooled cylinder design is to assure proper cooling. In considering this problem, two principles must be kept in mind, namely:

1. The ports which receive the most heat are the ports which require the most cooling air.

2. The least of cooling air must escape as directly as possible from the ports to be cooled, with a minimum dependence upon the conduction of heat through the walls.

The ports which receive the most heat during engine operation are the exhaust valve, exhaust port, combustion chamber and cylinder head.

In considering the cooling of the exhaust valve, it is obviously difficult to apply the second principle, since the valve is largely covered up by the valve seat, port, guide and spring.

The Tri-State Airway

By G. K. SPENCER

With the dedication of the "Tri-State Airway," opening direct air links between the East and the West (San Francisco, Arizona and California), the great Southwest is now to be having its place in the commercial world. The air route was dedicated May 16 and 17 at Tucson, Ariz., by Governors A. T. Hannett of New Mexico and G. W. P. Hunt of Arizona.

Since the early days of aviation in America, Arizona and New Mexico were looked upon as "the desolate states" by military officials who formed a great commercial future for the empire. Throughout the years these two states were looked upon as one of the way to an associated stage and state routes, when the citizens who work on the rising and growth element of the great Southwest demanded to be recognized as an advanced, little regard was given them by Army and State officials. Dedication of the new air route, personally the work of the heads and the heads of every member and member along it, definitely links Arizona and New Mexico as "the states" and it is expected that an official air mail route will be installed along the new airway.

The story of the long battle of the two states, with the aid of Southern California, was told by Governor Hannett, who delivered the dedicatory address before the citizens and citizens of Arizona, New Mexico and California. It was an account of the struggle of the early pioneers against the foothills of the Hope, Majors and Bear Indians, who preceded before the government following the dedicatory ceremony.

To complete were the citizens in obtaining air fields and equipment that today the "Tri-State Airway" is looked upon as a job well done in the country. Capt. Thomas T. Curren, who has flown over the air route and who commands the pilots at the Naval Air Station, North Island, Calif., says, "The 'Tri-State Airway' is one of the best in the country and is in some ways superior to those under the direction of the Navy and War Departments." This to staff is a tribute of which few airways can boast.

As a result of the enthusiasm of the citizens of the great Southwest every barrel, particularly on the new air line for new landing field, fully equipped to furnish all services with supplies and necessary maintenance and, many of the time were dedicated to the airway. Governor Hunt of Arizona told his audience of the dedicatory ceremony in speaking of the work of citizens and residents in establishing the "Tri-State Airway."

It was definitely announced at the dedicatory ceremony of the three states celebrating the opening of the route will divert their road commissions to a new road for new roads and roads under repair that shall be taken off the road every three miles. As a consequence of this order, all roads in Arizona, New Mexico and California will become virtually landing fields in themselves. It is expected that this plan will be adopted by other states, as much as "Mr. Ferguson" as governor of Texas has great interest in the plan and has expressed his approval of it. This is the first known action of the kind to be taken in the United States.

Associations Cooperate

Although the dedicatory ceremony was held under the auspices of state governments, the National Association of Airports, the Aero League of the Southwest and the Commercial Aircraft Association played an important part in the celebration. Citizens' organizations and representatives of the great Southwest into the ranks of presenters.

Unofficial, but authentic, information, obtained by the writer, indicates that air mail may be flown over the new airway within a short time. First "Blue" Blauvelt, chief engineer in the construction of the new air route, is now endeavoring to secure the rights to the air mail. It is expected that the commercial aviation firms operating on the Pacific coast will begin operating over the line between Los Angeles and Albuquerque within the month.

Some details of the facilities available follow:



Although the air route is unobstructed over much country, it is not unobstructed. Several landing fields are numerous and it is practically possible for a pilot to land and take off every three miles along the route. Where natural fields were sufficient, the construction turned out and constructed landing fields of their own. Another, a number of emergency landing fields, with the first on the line of the survey, which established its own landing field. According to Victor Mappa, who explained to the writer the work of the Airway, the larger emergency fields, every one, woman and child would be the establishment of the airway.

June 6, 1935

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only one new field is established. Golf links are 4 m. south of Victorville in a mesa.

Tucson, Ariz.—Good field 2 m. east of town, 2000 ft. square, with south on north end of field over country.

Phoenix to Gallup—Landings can be made all along route.

Phoenix to Albuquerque—Landings can be made all along route.

Phoenix, Ariz.—Field in east of town, south of railroad and north with half mile square, wind sock on southeast corner of field.

Phoenix to Ash Fork—Emergency landings can be made all along route.

Ash Fork, Ariz.—Good emergency field north of railroad about 100 yd. long and 300 ft. wide. Several places have landing fields.

Flagstaff, Ariz.—Phoenix Field is half mile east of town, north of railroad and highway, and west of branch line running to Flagstaff, Ariz. shape field. One emergency landing field in town, south of town and east of town. Each runway is a quarter of a mile long and 300 ft. wide. Wind sock on corner running north and south on west side of field 100 ft. LAND where you see the three white clouds as you fly in the old field.

Flagstaff, Ariz.—Field is north of railroad one quarter of a mile. You will see two large water tanks at railroad station, the first on north end of the field and the highway. Wind sock on north end of field. Field is about 100 yd. long and 300 ft. wide. Emergency fields are plentiful between Phoenix and Flagstaff.

Flagstaff, Ariz.—Field is southeast of town, north of a three story brick high school. Wind sock on a barn south of school. First field is 400 yd. long, north end north is half mile long and 300 ft. wide. Second field is 400 yd. long and 300 ft. wide. Third field is 400 yd. long and 300 ft. wide. Fourth field is 400 yd. long and 300 ft. wide. Fifth field is 400 yd. long and 300 ft. wide. Sixth field is 400 yd. long and 300 ft. wide. Seventh field is 400 yd. long and 300 ft. wide. Eighth field is 400 yd. long and 300 ft. wide. Ninth field is 400 yd. long and 300 ft. wide. Tenth field is 400 yd. long and 300 ft. wide. Eleventh field is 400 yd. long and 300 ft. wide. Twelfth field is 400 yd. long and 300 ft. wide. Thirteenth field is 400 yd. long and 300 ft. wide. Fourteenth field is 400 yd. long and 300 ft. wide. Fifteenth field is 400 yd. long and 300 ft. wide. Sixteenth field is 400 yd. long and 300 ft. wide. Seventeenth field is 400 yd. long and 300 ft. wide. 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Program of N.A.A.

Policy Outlined in Program and Resolutions Adopted at St. Joseph Meeting

The Resolutions adopted at the meeting of the Board of Governors, National Aeronautic Association of U.S.A., at St. Joseph, Mo., April 30, 1938, are the most comprehensive that have yet been presented to the membership. They indicate that a careful survey of national air problems has been made. The program is an officially adopted following:

1. To maintain a non-commercial, civilian organization whose influence shall always be directed toward the advancement of Aeronautics in the U.S.A.
2. To formulate and support a constructive and comprehensive national program of air development, to be carried out by governmental authorities during the next decade.
3. To conduct a course by which all other organizations may cooperate in furthering the American aeronautical cause.
4. To foster and improve aviation interests directed to the progressive development of aviation and aircraft which will be most accessible to the government and to civilian enterprise.
5. To function as the representative of the F.A.I. in certifying records of aeronautical performance and all other matters.
6. To represent this country in the F.A.I. and in other international aeronautical conferences where civilian representation is proper.
7. To protect the industry from governmental monopoly of aircraft engineering and from destructive competition in letting of government contracts.
8. To bring about the creation of standing aviation commissions in both houses of Congress.
9. To urge Congress to pass a comprehensive bill to regulate and foster civilian aviation through a Bureau of Civil Aeronautics in the Department of Commerce.
10. To advocate the regulation by the U. S. B. of the International Air Navigation Convention with reservations.
11. To work in securing landing fields and air navigation facilities, to be provided by governmental and private enterprise.
12. To encourage the use and extension of the U. S. Air Mail.
13. To collect and disseminate information as to practical use of aircraft in transportation, agriculture, forestry and other fields.

The Resolution that were adopted were as follows:
Furthering Activity of Government Departments
 "That the President direct the Federal statute, permitting the Army, where naval specifications are of military importance, to buy airplanes without competitive bids, be extended to the purchase of aircraft, and that where aircraft are bought by the United States Government for military purposes, and it is thought by the purchasing department that the wisdom of the design is of importance to the Government, that they have authority to buy such aircraft without competitive bids."
Open Abandonment of Government Aircraft Manufacturer
 "That the N.A.A. urge the Government to abandon the monopoly of the manufacture of military aircraft in the Navy, and invite by all its engagements in the use of aircraft from congressional production, and on the basis of merit, performance, meeting specifications to capacity for production."
Open Bidding Tests
 "That it is the sense of the Board of Governors of the N.A.A. that the Army and Navy should be requested to give particular attention to the matter of landing in connection with the Air Services of both branches of the National Defense and to the best possible organization of air attack."
Enforce Principles of Kelly Bill
 "That a committee be appointed to draft a resolution endorsing the principles of the Kelly Bill, requesting the Postmaster General to put it into an executive operation as far

possible within the means allotted to him, and asking those who are in a position to, to lend their assistance under the Kelly Bill."

Recommendations Forest Fire Policy

"That, where practical experience in Canada and other geographical facts in many portions of the forested areas of the United States would tend to show that the cost of forest fire control can be reduced and the protection against forest fires be improved by the use of airplane forest fire fighting."

"Therefore, be it resolved by the Board of Governors of the National Aeronautic Association that the advancement of airplane forest fire fighting be brought into the attention of the members of the National Forestry, the several State Forestry, and the press and public of the country, and that they be urged to initiate experiments with this form of fire control."
Try Organization of International Air Convention

"That the chair be empowered to appoint a committee of three to wait upon the Secretary of State and the President of the United States, to present to them a petition that the International Air Convention of October, 1934, be revised to make such modifications as our welfare require."
Stimulate Cooperation of U. S. Chamber of Commerce

"That the delegates of the National Aeronautic Association be authorized to join in proposing to the United States Chamber of Commerce that the delegates declare, so that the President of your Association be empowered to secure the necessary approval by other members of the United States Chamber of Commerce."

"The National Aeronautic Association of the U.S.A., proposes a declaration endorsing the principles and methods heretofore sanctioned by the Board of Governors for the development of this form of country, be it."

The passage by the House of Representatives of a Federal Statute organizing the civil bureau of aeronautics as the Bureau of Commerce for the Federal supervision of air traffic, to transportation and the carrying of pilots, the inspection and licensing of aircraft, the establishment of air routes, the dissemination of aeronautical information and statistics, the regulation of foreign air commerce and our participation in air commerce, the provision for the creation of an American merchant air fleet.

We urge upon the National Executive the desirability of forming the International Air Navigation Convention (1934), and thus providing for our participation in an air-aided flight.

We urge upon every unit of our organization and state the desirability of adequate landing fields for the present and future.

We urge the further development of the air mail and rapid extension of the air mail service as far as it is possible to make it really profitable for the government.

We recommend increased governmental appropriations for Aeronautics."

New York Public Law Resolutions

"That the N.A.A. be authorized to write to New York and New Jersey that the N.A.A. will be very pleased to move its operations from New York for the Public Law to be in the state, in view of the fact that their bills have been passed by the National Aeronautic Association."

"That the name of the Elimination Bill, New York, be changed to 'National Defense'."

N.A.A. Study to Make Performance Tests

"That the President authorize that the N.A.A. be empowered to make official performance tests and that the results of these tests be made known to the members of the Association, subject to the approval of the President."

American Work Program—Commercial Air Meet

"That, where practical experience in Canada and other geographical facts in many portions of the forested areas of the United States would tend to show that the cost of forest fire control can be reduced and the protection against forest fires be improved by the use of airplane forest fire fighting."

"Therefore, be it resolved by the Board of Governors of the National Aeronautic Association that the advancement of airplane forest fire fighting be brought into the attention of the members of the National Forestry, the several State Forestry, and the press and public of the country, and that they be urged to initiate experiments with this form of fire control."

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"That the chair be empowered to appoint a committee of three to wait upon the Secretary of State and the President of the United States, to present to them a petition that the International Air Convention of October, 1934, be revised to make such modifications as our welfare require."

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"That the name of the Elimination Bill, New York, be changed to 'National Defense'."

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was put forward by Mr. Edwards. He pointed out that by using a variable timing gear in conjunction with a high compression ratio, and by increasing the compression of closing the inlet valve late so that compression would not start until well up the compression stroke when near ground level, then the timing could be gradually changed by the pilot, with a predetermined altitude control timing would be employed. By this means ground level power would be obtained up to the height at which the maximum timing would be employed. From that height onwards, the I.L.P. of the engine would of course fall off, as with normal compression ratio engines, but there would be a considerable increase of I.L.P. available at all altitudes, and a marked fuel economy. This scheme for increasing the engine performance at altitude is far preferable to an extreme high compression throttled engine, even such as with the former certain definite advantages are secured, such as a more linear curve, a short run compression and long expansion stroke, with its absence of preignition and detonation, etc. Owing to difficulties in making conventional "in line" engines, the use of a variable timing gear, which would be a marked improvement in the engine, was never developed.

On the "Strut" Jupiter Radial Alcocked engine it has been possible to obtain a practical solution of the variable timing gear, for engine to the patented double eccentric timing gear it is quite simple to arrange that the period of opening the valves can be easily changed while the engine is running, and allowing for the intake valve rate of the engine, viz., 1.5 to 3, it has been possible to design the cylinder



The fixed variable timing gear for the Jupiter engine described in the above paper, showing its stationary nature.

with 6.5 to 1 compression ratio without obtaining an inefficient combustion chamber.

The Alcocked engine is a double valve gear controlling the stationary nature of the timing gear. No moving parts of the engine are affected, so that the reliability of the engine is not disturbed from the best, and the additional weight to the engine is only 1 lb.

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